

Work Order ID 165810

Tuesday, August 29, 2017 3:19:02 PM

165810

Page 1

Item ID: D4038-8

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Block

Start Date: 9/6/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

W ^{DAS} 21 ₉₋₈₉

Date: AUG 30 2017 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

0.00

100

Bandsaw

Memo

0.08

Jeaspa Bandsaw

CUT BLANK 2.30" LONG

4x

Ø

unl
2017/09/07

105

0.58

105

HAAS I

Memo

1.25

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA884

DWG REV: *E*

FOLIO REV: *A*

DEBURR

4x

Ø

unl
2017/09/07

Tuesday, August 29, 2017 3:19:02 PM

Page 2

[illegible]

Work Order ID 165810

Tuesday, August 29, 2017 3:19:02 PM

165810

Page 3

Item ID: D4038-8

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Block

Start Date: 9/6/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				4	0	SEP 11 2017	DAS 9 9-89
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location	0.00				4		SEP 12 2017	
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

SEP 13 2017

Picklist Print

Tuesday, August 29, 2017 3:19:01 PM

Page 1

Work Order ID: 165810

165810

Parent Item: D4038-8

D4038-8

Parent Item Name: Block

Start Date: 9/6/2017

Required Date: 9/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No			100	f	12.2070	0.166	0.698947			

M6061T6B1 500X02 000

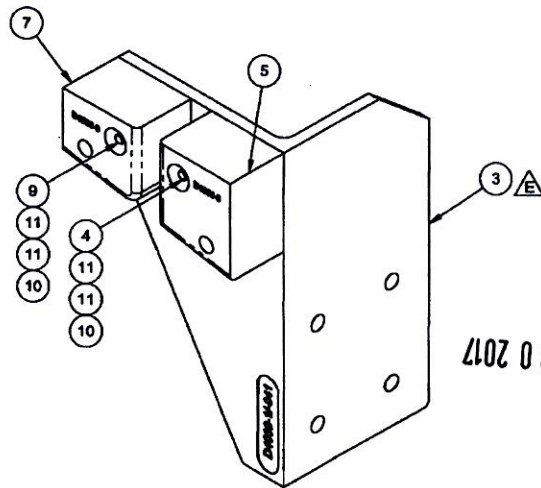
**

6061-T6 Bar 1.50 x 2.00

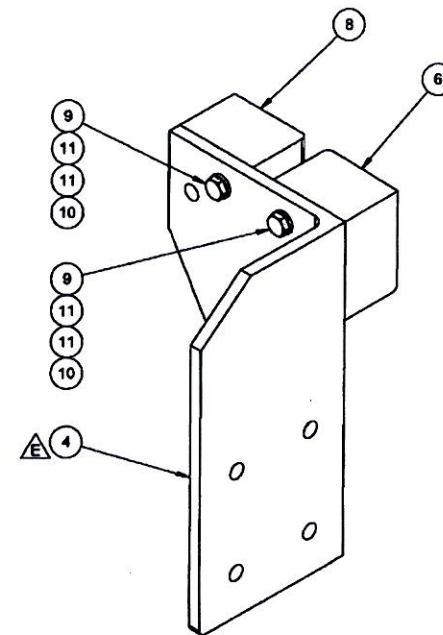
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	0.207	
→ m134677	0.207	
MAT004	12	
→ m137043	12	

207
191
2017/09/07
2017/09/07

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-041 ANGLE ASSEMBLY, FWD, LH



D4038-042 ANGLE ASSEMBLY, FWD, RH

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2011-04-21
JMB

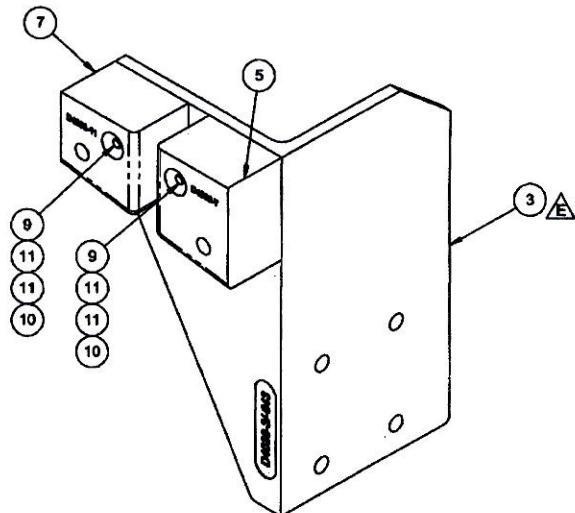
AUG 30 2017

NO. 165810
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

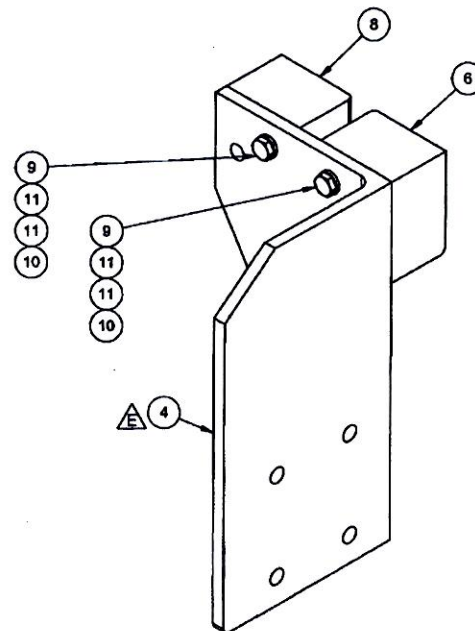
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -041 - 1.75 lbs
-042 - 1.74 lbs

E	1.19 X 1.00 CHAMFER WAS R1.00. REF: NCR11-543.	MB	11.04.11
D	REVISED D4038-7/8-11-12 AS FOLLOWS: 1.87 WAS 1.73 (C7-9); 2.14 WAS 2.00 (C4-9); 2.13 WAS 2.00 (C7-10); 1.86 WAS 1.73 (C4-10); 1.52 WAS 1.38 (C7-13); 1.79 WAS 1.65 (C4-13); 1.77 WAS 1.65 (C7-14); 1.48 WAS 1.38 (C4-14). REASON: NCR11-458.	MB	11.03.03
C	REVISED D4038-3/4 AS FOLLOWS: 0.589 WAS 0.714 (B2-5, B4-6); D4038-043/044 ARE AFFECTED. REASON: NCR11-399.	MB	11.01.20
B	REVISED DIMENSIONS ALL SHEETS, ADD Ø0.318 HOLES IN -1A-2A-3A-4 PARTS, ADD RADIUS TO -1A-2A-3A-4 PARTS	HS	10.01.06
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		
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ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-043 ANGLE ASSEMBLY, AFT, LH



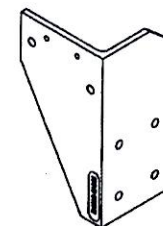
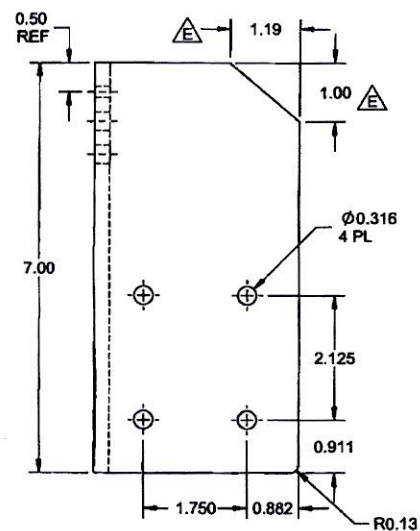
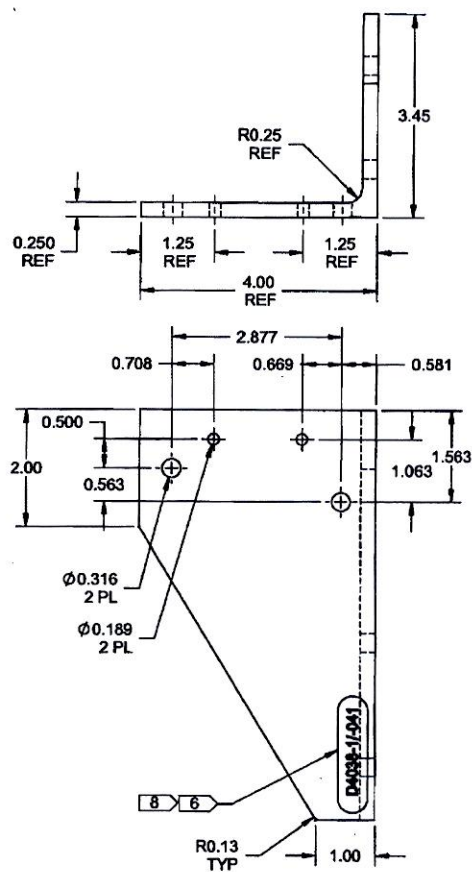
D4038-044 ANGLE ASSEMBLY, AFT, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -043 - 1.96 lbs
-044 - 1.74 lbs

RELEASED
2011-04-21

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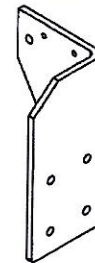
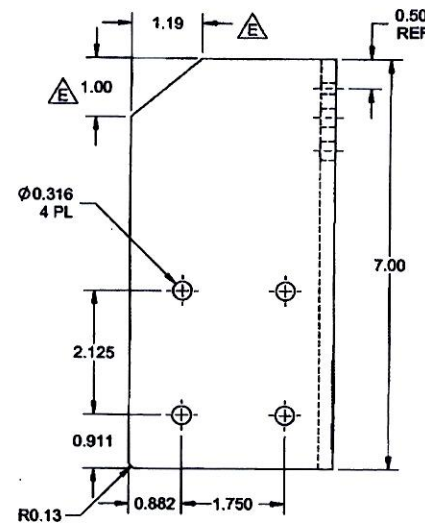
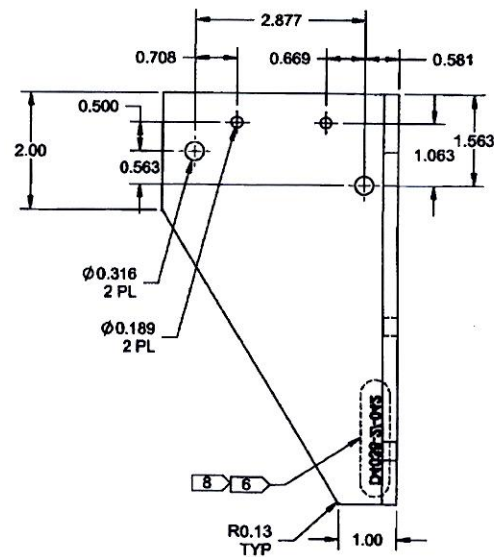
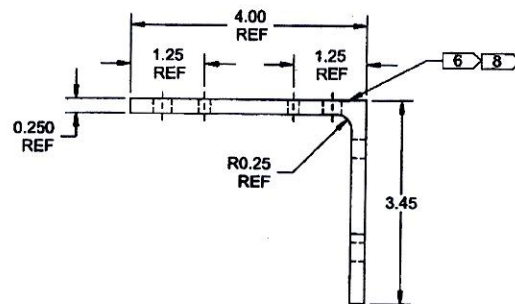
D4038-1 ANGLE, FWD, LH

RELEASED
2011-04-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

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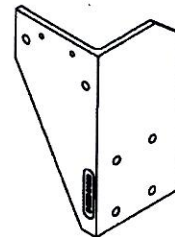
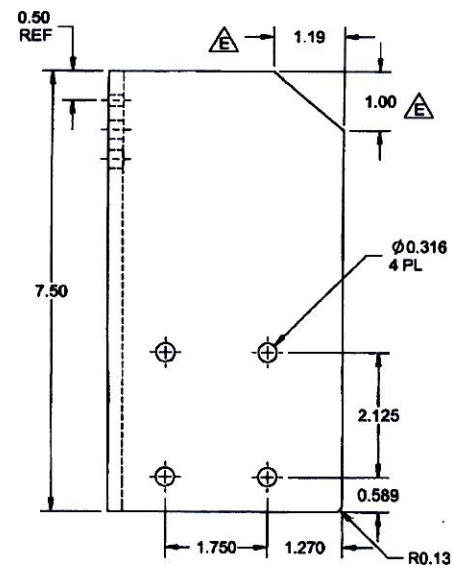
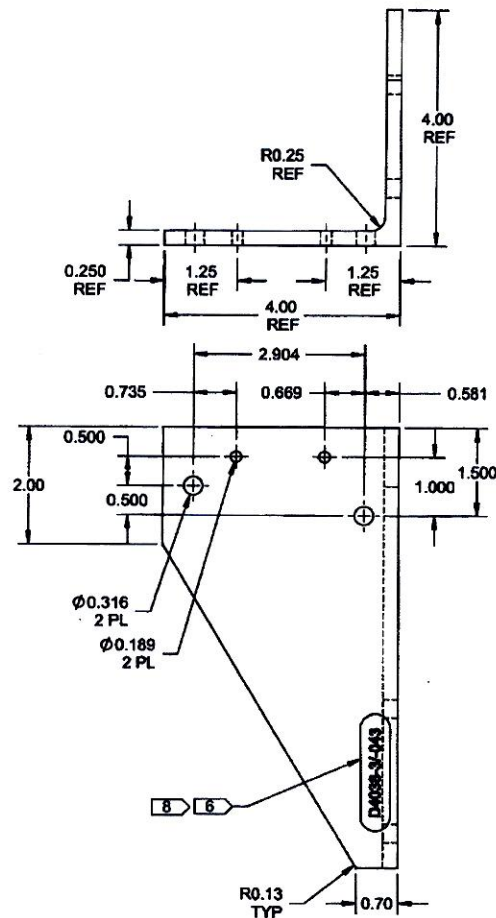
D4038-2 ANGLE, FWD, RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

RELEASED
2011-04-23
MD

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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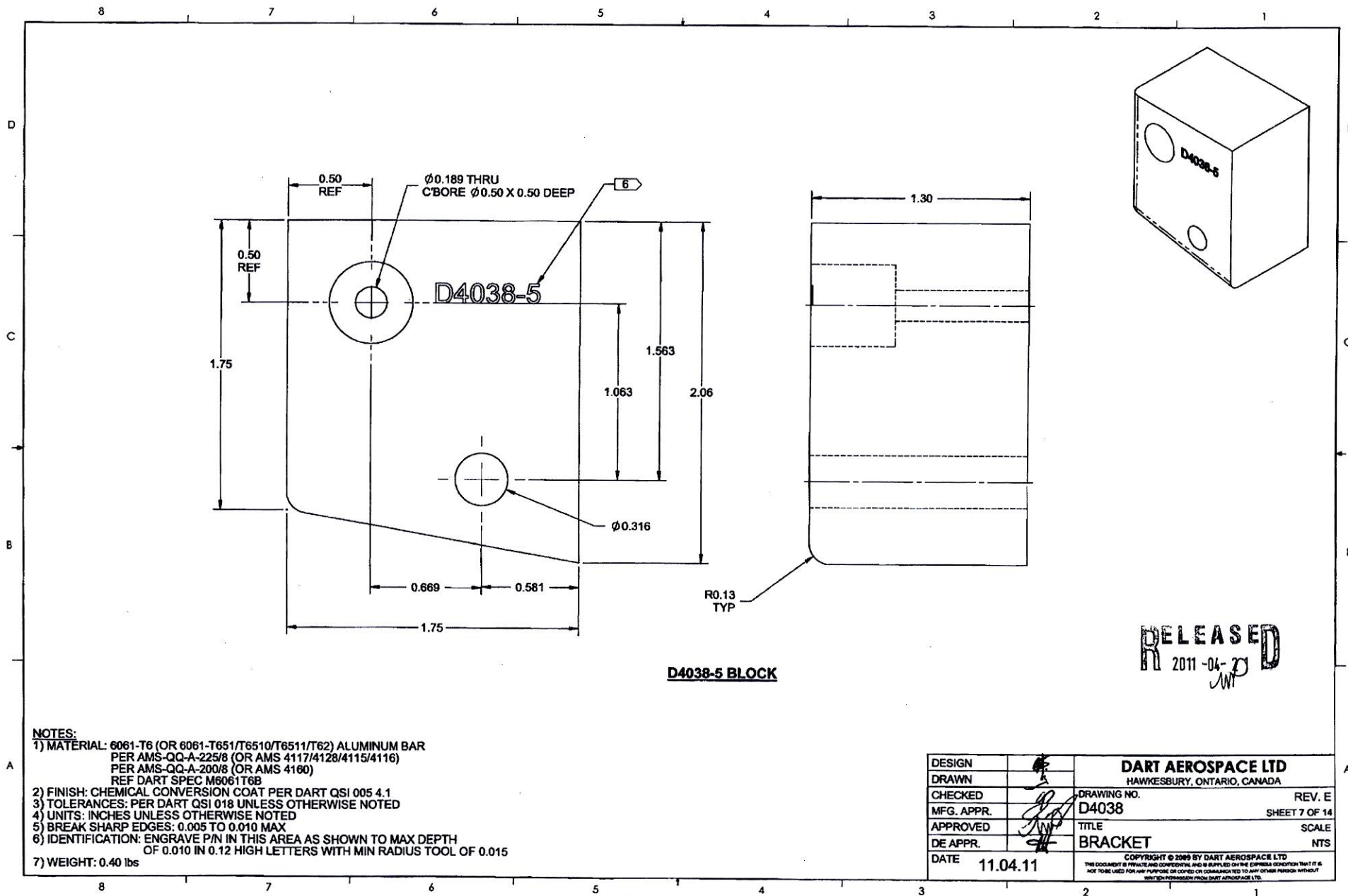


- NOTES:**
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.18 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

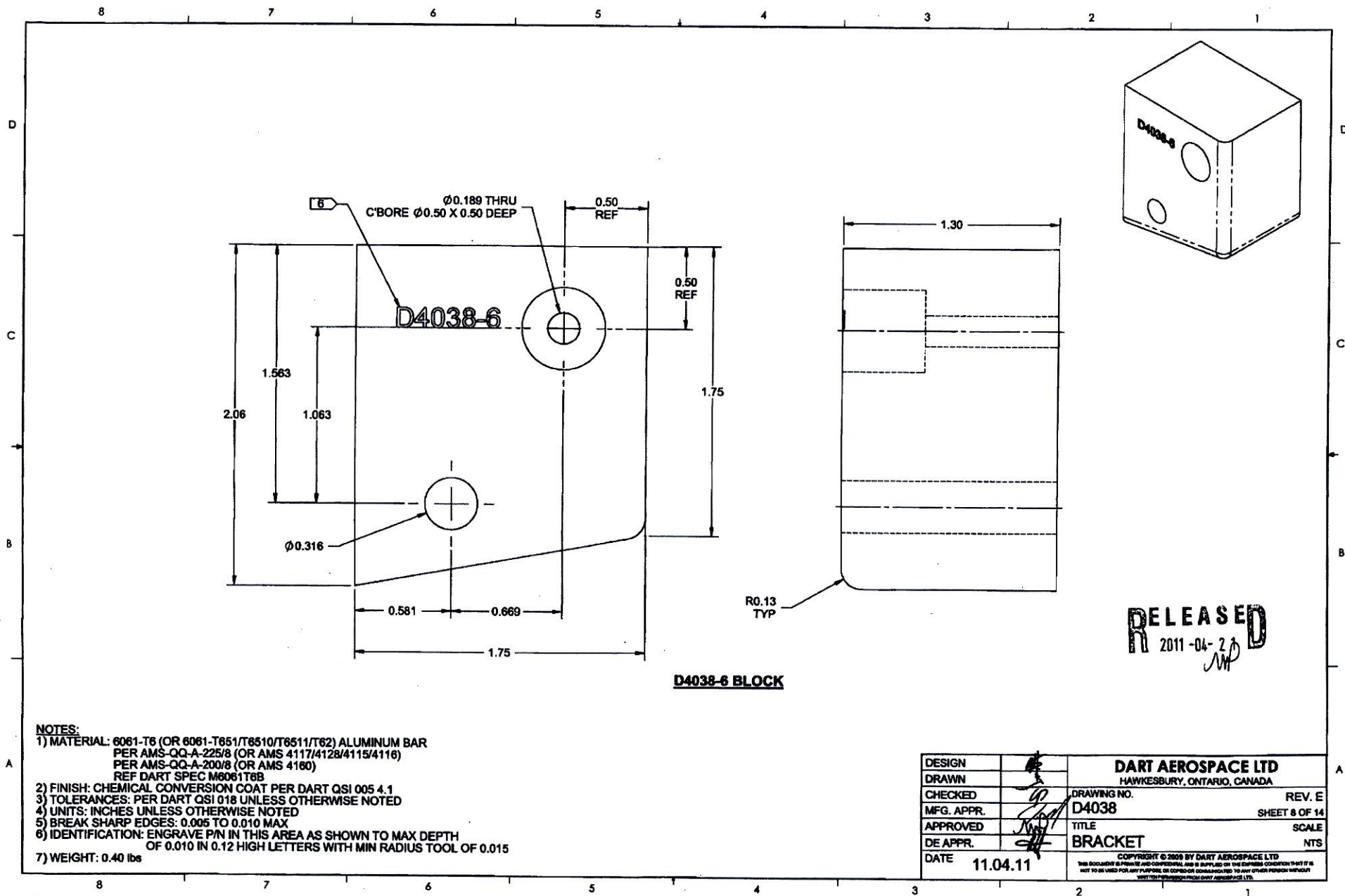
D4038-3 ANGLE, AFT. LH

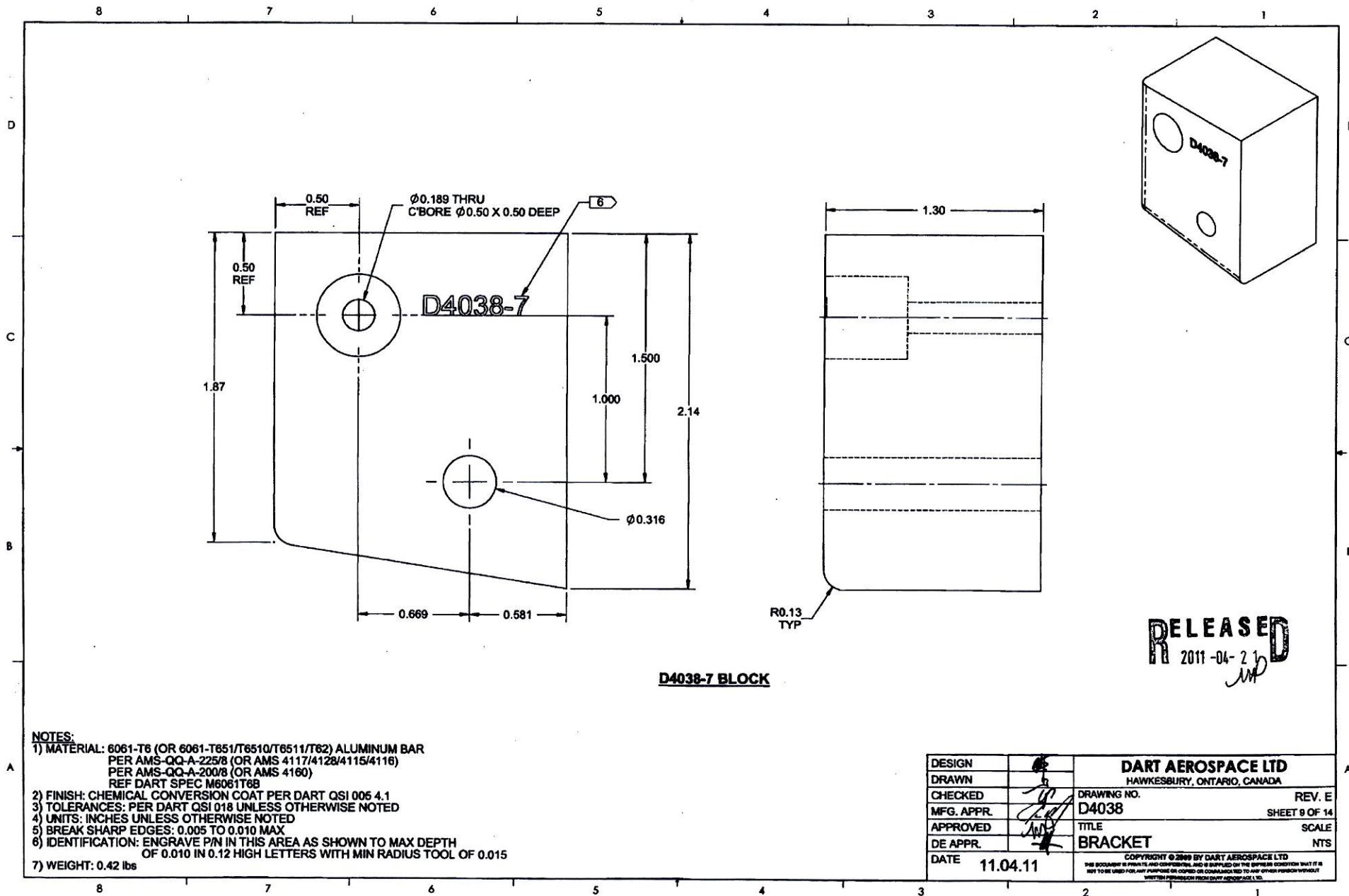
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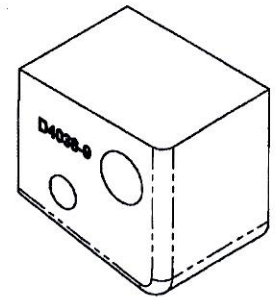
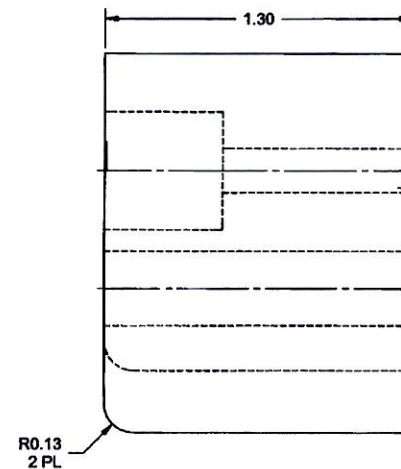
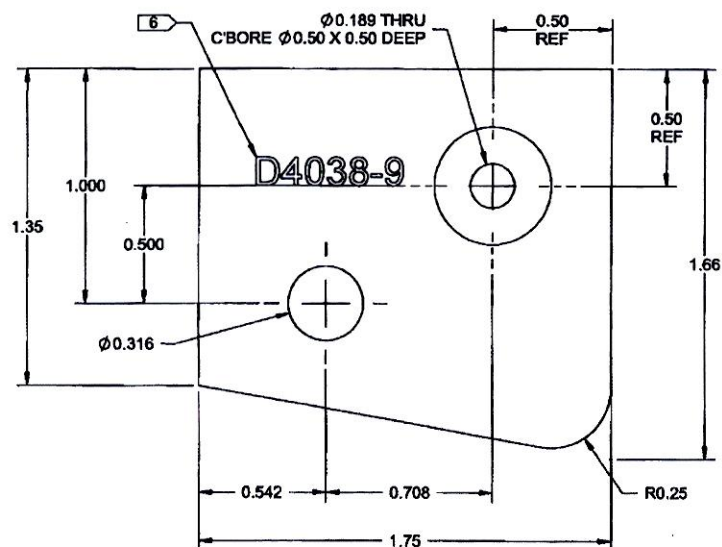
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2011-01-21
JMT



RELEASED
2011-04-27







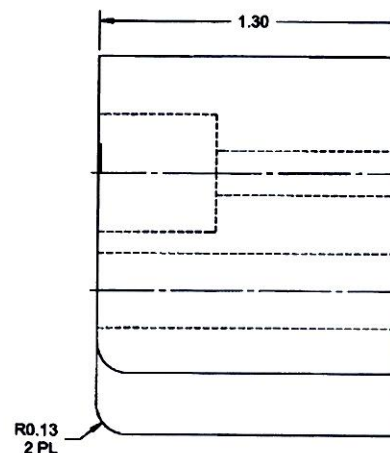
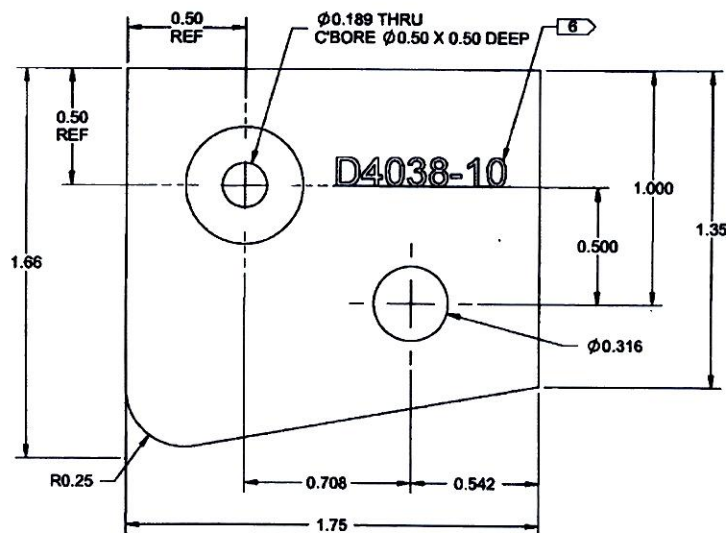
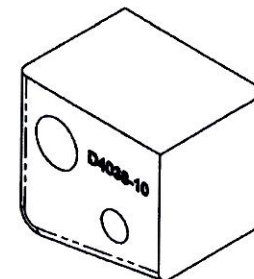
D4038-9 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

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2011-04-21

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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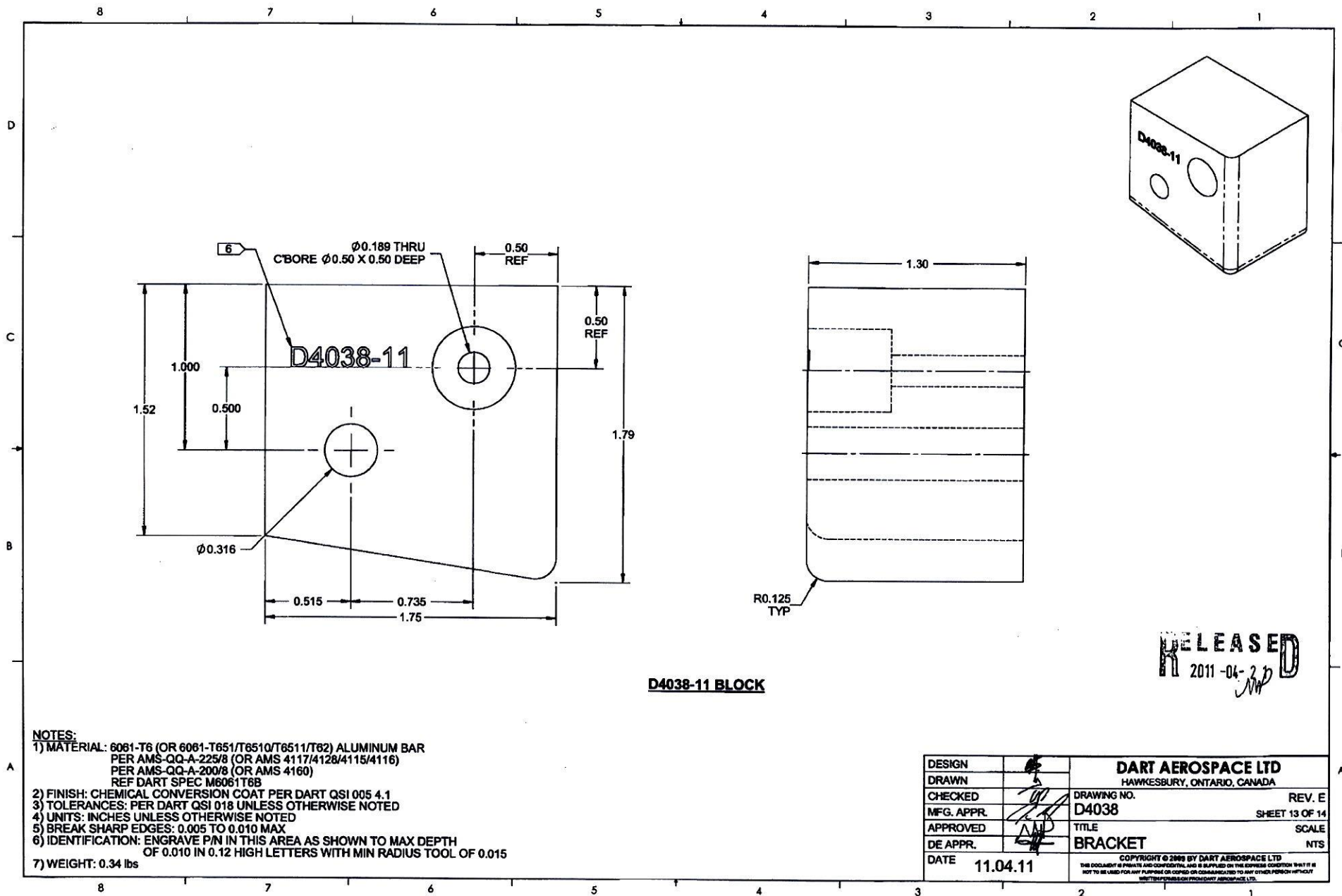


D4038-10 BLOCK

RELEASED
2011-04-22

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M0061T68
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 0.31 lbs

DESIGN			DART AEROSPACE LTD	
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CHECKED			DRAWING NO.	REV.
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D4038-11 BLOCK

